

Date: Thursday, 10/11/2007 2:54:08 PM  
User: Kim Johnston

Process Sheet

|                       |  |                  |               |      |    |
|-----------------------|--|------------------|---------------|------|----|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : STRUT       |      | 0  |
| Job Number            | : 35119  |                  |               |      |    |
| Estimate Number       | : 10957  | Part Number      | : D2565205    |      |    |
| P.O. Number           | : N/A  | Drawing Number   | : D2565 REV E |      |    |
| This Issue            | : 10/11/2007   | Project Number   | : N/A         |      |    |
| Prsht Rev.            | : NC   | Drawing Revision | : E           |      |    |
| First Issue           | : N/A  | Material         | : N/A         |      |    |
| Previous Run          | : 31969  | Due Date         | : 10/17/2007  | Qty: | 10 |
| Written By            | :  |                  |               | Um:  | 5  |
| Checked & Approved By | :  |                  |               | Each |    |
| Comment               | : Est: E 01.08.28 Added Powder coat, and added Inspetion Levels 3 and 21. SM |                  |               |      |    |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 1.8812 f(s)/Unit Total: 9.4059 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall  
(M304TR0750W049)

Batch No: M105732

SB 07/10/16

(10)

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC

Punch as per Dwg D2565 using DT 8313

SB 07/10/16

(10)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill hole as per Dwg D2565 (one end only)  
Deburr and polish

SAD 07-10/18

(10)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter  
07/10/18

(410)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M105068

(10x)

m-h 07/10/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/10/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35119

Part Number: D2565205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*Le 7/10/22*

*(10)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57253

*Le 7/10/22*

*(10)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*12/07/10/22*

Job Completion



*U 07/10/22*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

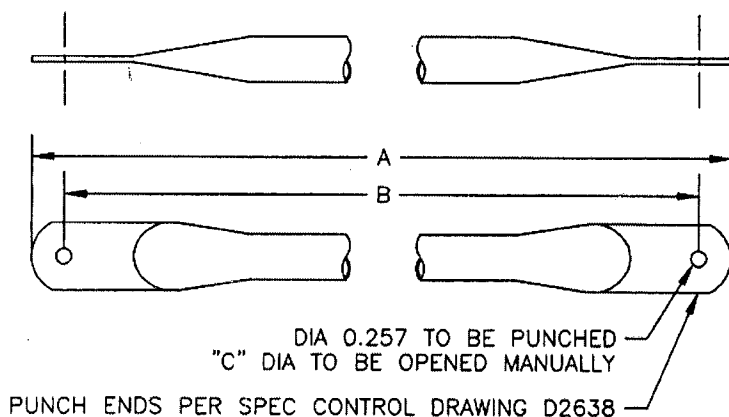
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |          |  |                        |
|------------------|----------|--|------------------------|
| DESIGN           | DRAWN BY | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED          | APPROVED | DRAWING NO.<br>D2565                                     | REV. E<br>SHEET 1 OF 1 |
| DATE<br>04.05.05 |          | TITLE<br>STRUT   | SCALE<br>1:3           |
| A                | 96.05.03 | NEW ISSUE  |                        |
| B                | 97.03.15 | CORRECT D2565-111 DIM. A                                 |                        |
| C                | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603)                         |                        |
| D                | 02.06.05 | ADD -3XX PARTS; ADD FINISH                               |                        |
| E                | 04.05.05 | ADD D2565-401-411; RMV ANGLE D                           |                        |

RELEASED  
04.05.05



| PART #    | A     | B     | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | -     |
| D2565-109 | 12.31 | 11.51 | -     |
| D2565-111 | 13.65 | 12.85 | -     |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | -     |
| D2565-209 | 15.16 | 14.36 | -     |
| D2565-211 | 14.14 | 13.34 | -     |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | -     |
| D2565-309 | 20.17 | 19.37 | -     |
| D2565-311 | 16.30 | 15.50 | -     |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99  | -     |
| D2565-409 | 9.34  | 8.54  | -     |
| D2565-411 | 13.81 | 13.01 | -     |

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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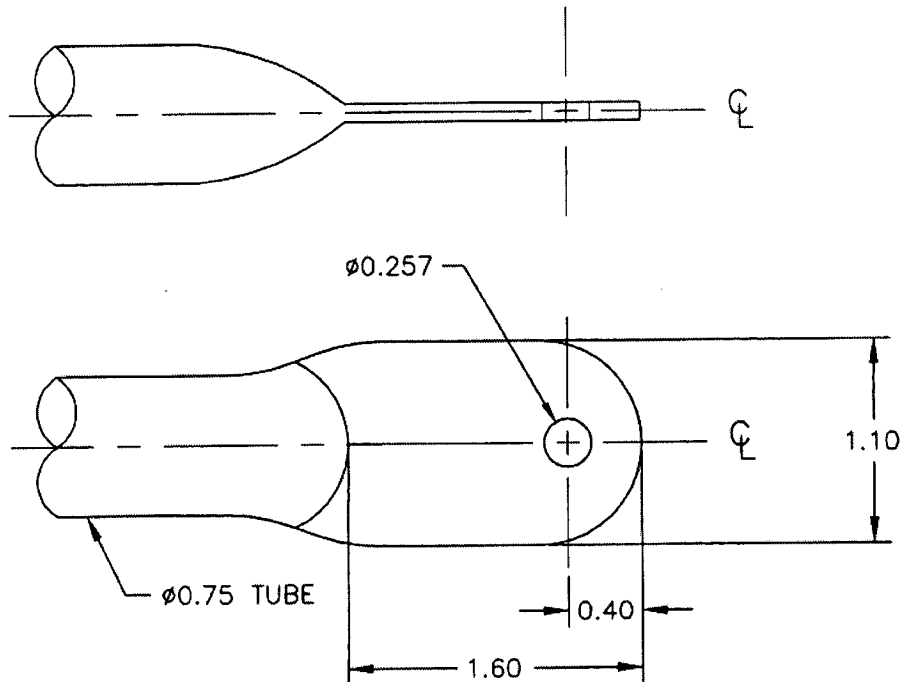
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|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>KE</i>  | DRAWN BY<br><i>KE</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>DM</i> | APPROVED<br><i>KE</i> | DRAWING NO.<br>D2638                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>98.04.28     |                       | TITLE<br>PUNCH DT8117 SPEC CONTROL                | SCALE<br>1:1           |
| A                    | 98.04.28              | NEW ISSUE   |                        |

RELEASED  
78/05/05 KE

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8117



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